

**METHODS OF PREPARING DIDESMETHYLSIBUTRAMINE  
AND OTHER SIBUTRAMINE DERIVATIVES**

**ABSTRACT**

5        This invention encompasses novel methods of preparing sibutramine and  
sibutramine derivatives, and stereomerically pure sibutramine derivatives in particular.  
Examples of sibutramine derivatives include, but are not limited to, sibutramine metabolites  
such as desmethylsibutramine and didesmethylsibutramine. The invention further  
encompasses novel compounds useful in the synthesis of sibutramine derivatives.

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